

Claims

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3 1. Window wiper, in particular flat beam window wiper for vehicles, having a
4 spring strip back (10) that exhibits a variable strip thickness (d) across the length
5 of the back (l), having a connecting device (11) situated in the middle on the
6 spring strip back (10) for a wiper arm (12), and having a rubber-elastic wiper strip
7 fastened to the spring strip back (10), characterized in that the spring strip
8 back (10) is refined in such a way that it exhibits a quasi constant course of
9 strength or hardness along the length of the back.

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11 2. Window wiper according to Claim 1, characterized in that the spring strip
12 back (10) is heated to a hardening temperature in a continuous operation, then
13 quenched and, to temper it, heated to a tempering temperature in such a way
14 that it does not reach the tempering temperature until immediately before it
15 leaves the tempering zone.

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17 3. Window wiper according to Claim 2, characterized in that the tempering
18 zone is divided into multiple temperature zones, and that the spring strip back
19 (10) is moved through the temperature zone in such a way that it passes through
20 the temperature zone last that brings about the tempering temperature.

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22 4. Window wiper according to Claim 3, characterized in that the length of the
23 last temperature zone in the pass-through direction of the spring strip back (10) is
24 coordinated with the pass-through speed of the spring strip back (10) in such a
25 way that the spring strip material reaches the tempering temperature as late as
26 possible.

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28 5. Window wiper according to one of the Claims 2 through 4, characterized in
29 that the spring strip back is heated using thermal radiation.

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1 6. Window wiper according to one of the Claims 3 through 5, characterized
2 in that the last temperature zone in the pass-through direction of the spring strip
3 back (10) is thermally well isolated from the preceding temperature zones.

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